

Date: Thursday, 11/29/2007 11:04:33 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	36031					
Estimate Number	10834					
P.O. Number				Part Number	D29332	
This Issue	11/29/2007		S.O. No.	Drawing Number	D2933 REV C	
Prsht Rev.	NC			Project Number	N/A	
First Issue	/ /		Type	Drawing Revision	C	
Previous Run	34616			Material		
Written By				Due Date	12/15/2007	
Checked & Approved By				Qty:	6	
Comment	Est: B 00-06-26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>B 34872</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:04:34 AM
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Process Sheet

1 Customer: CU-DAR001 Dart Helicopters Services Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 36031

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/03/27

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL

08-03-25

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

08/03/25

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-26

X6

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428A

8316 54

CH

(b)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

(6)

Job Completion



mk

08-03-27

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	36031
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.123	.123		
B	0.100	0.140		.123	.123	.123	.123		
C	0.100	0.140		.125	.125	.125	.124		
D	0.210	0.230		.222	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.236	.236	.236	.236		
N	0.100	0.140		.119	.119	.119	.119		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.505	.505	.505	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.130	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.580	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SP	Audited by:	SD
Date:	08/03/19	Date:	08/03/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM SP	SP

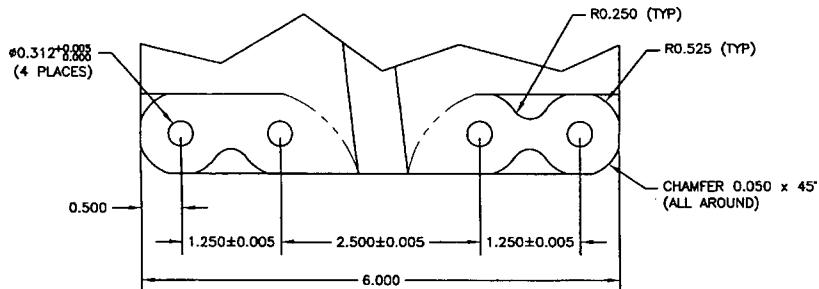
DART AEROSPACE LTD	Work Order:	36031
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

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G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.578	1.578				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.236	.236				
N	0.100	0.140		.118	.118				
O	0.540	0.560		.545	.550				
P	0.490	0.510		.503	.501				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.495	2.495				
S	0.240	0.270		.250	.250				
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V	1.362	1.372		1.370	1.370				
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Y	1.565	1.585	DT8695 A/B	1.570	1.570				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>RF</i>	Audited by:	<i>SD</i>
Date:	<i>28/03/19</i>	Date:	<i>08/03/27</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>SD</i>

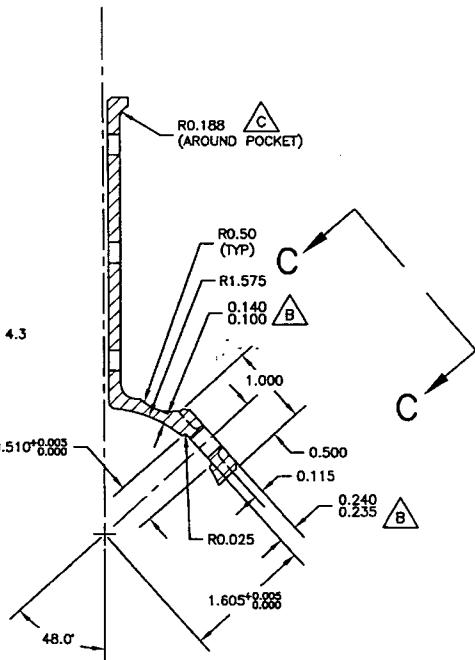


VIEW C-C

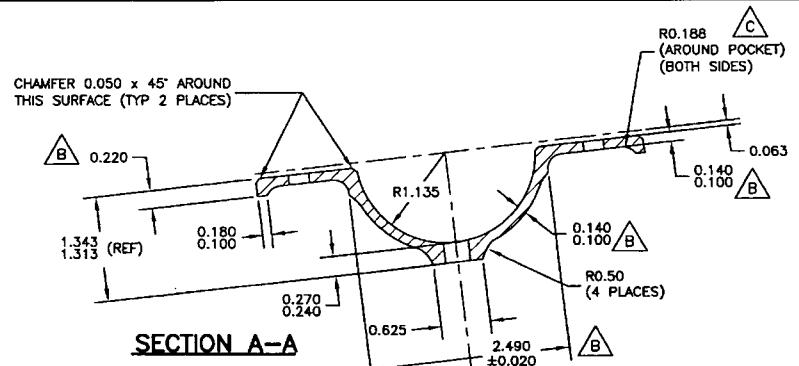
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

Notes

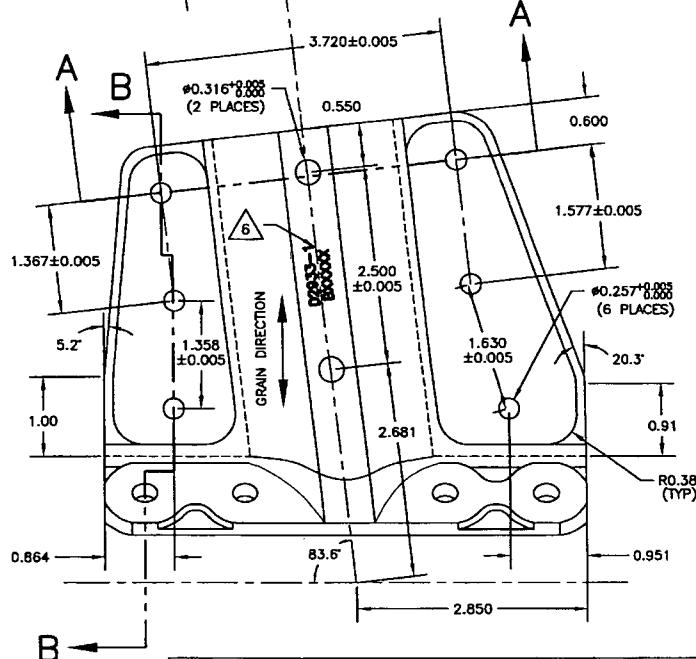
1) MATERIAL: ALUMINUM 7075-T7351 (QO-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



B

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN <i>4</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2933
DATE 06.11.09	TITLE SADDLE INSIDE	REV. C SHEET 1 OF 1 SCALE 2-3

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